

Monday, 10/23/2006 12:02:00 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 29098
Estimate Number : 12347
P.O. Number : N/A
This Issue : 10/23/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LANDING GEAR
Previous Run : 29097
Written By :
Checked & Approved By :
Comment : Est Rev: F 06.09.01 Add holes for compatibility with Bell Skidtubes, KJ/JLM

Drawing Name : 206B END X-TUBE
Part Number : D206667201
Drawing Number : D206-667-241 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 11/20/2006 Qty: 1 Um: Each

Handwritten: AFT 06-02-23

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-201 CHG002

2.0	D6003102	Crosstube
-----	----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6003-102 Crosstube 25603

Check OD = 2.250"; ID = 1.380"

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA084

2-Turn first side as per Folio FA084

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/10/24

WORK ORDER CHANGES

W/O: 2

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Date: Monday, 10/23/2006 12:02:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 29098

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA084

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

3-Polish entire outside surface of crosstube

JD-6-12-7 ①

4-Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-241

Inside of Cuff(Donot engrave on outside of tube)

SA 06.10.26

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SA 06.10.26

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.11.09

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DP/JH

6-12-7

9.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-241 using CNC bender program 206B-AF and Folio FT

DP 7-1-18

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

SA 07/01/22 ①

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

SA 07-01-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/23/2006 12:02:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 29098

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description:

2-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate tube using "T" pins off holes drilled in previous step.

4-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

5-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576. Check dimensions between holes on all four sides to ensure proper alignment. Use DT8583 & 8584 SUPPORT Jigs.

6-Drill rivet holes as per Dwg D206-667-241 using drill Jig DT8788.

7-C'sink holes as per Dwg D206-667-241

8-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241

07-01-23

07-01-23

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-01-23

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-02-06

07/04/26

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-02-06

07/04/26

15.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 3644

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

07/04/26

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

07/05/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/23/2006 12:02:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 29098

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

18.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

85
07 07 19

19.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

ml 07 07 22

20.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip 32020

ml 07 07 22

21.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support 28388

ml 07 07 23

22.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22 Clamp 104902

ml 07 07 23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/23/2006 12:02:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 29098

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579.

2-Install supports and clamps as per Dwg D206-667-241. Torque clamps to 80-100 in lb

7 ml
07/07/23

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/07/24 (41)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

1103481 ✓

EP. ✓

27.0

D2872043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2872-043

Nut Plate

B24151 ✓

EP. ✓

28.0

D2872045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2872-045

Nut Plate

B24152 ✓

EP. ✓

EP 07/04/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/23/2006 12:02:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 29098

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

M102959 ✓

30.0

AN530A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-30A

Bolt

M103389 (6x) ✓

M19522 (4x) ✓

31.0

AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

20 AN960JD516

Washer

M104156 ✓

32.0

MS21042L5

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 MS21042L5

NUT

M103830 ✓

33.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-201

Location:

PPP Rev:

EP5 2/07/24 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/23/2006 12:02:01 PM
User: Kim Johnston

Process Sheet

Customer: CUJ-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 29098

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DD 07107124

Job Completion



U 07-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 29098
Description: Crosstube Assembly	Part Number: D206-667-241
Inspection Dwg: D206-667-241 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

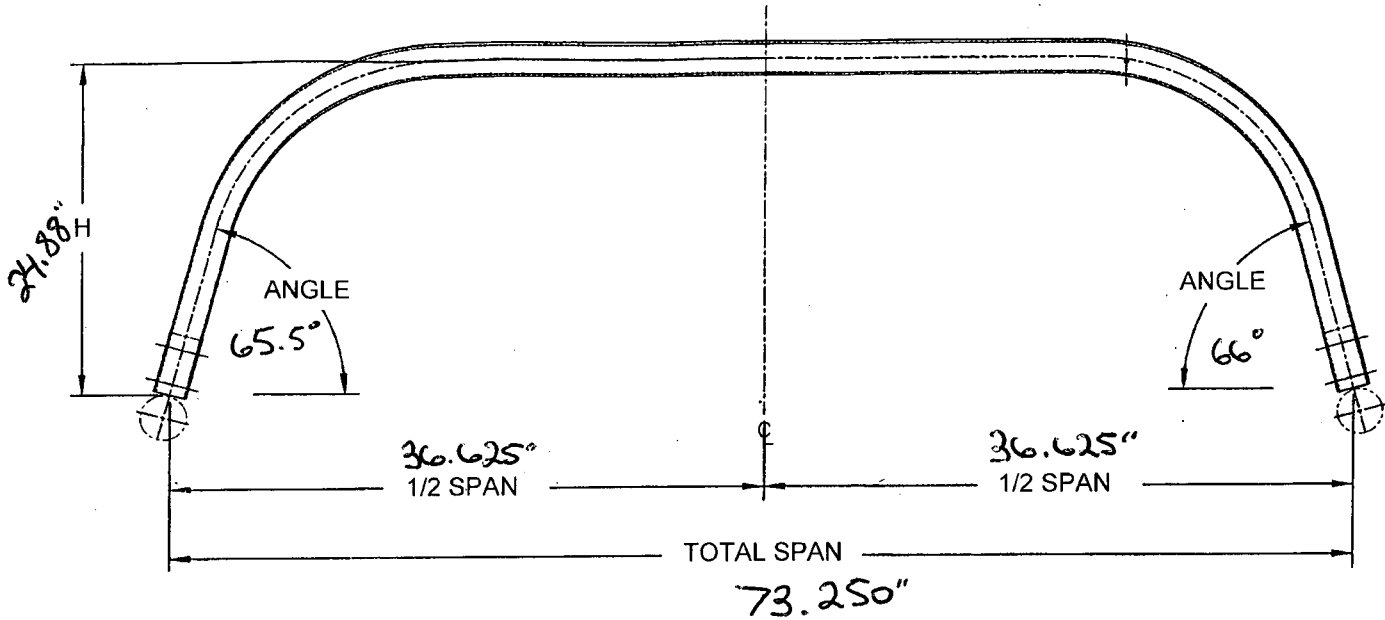
☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	30° x 0.500	+/-0.010	.500	✓		
	0.250	+/-0.010	.250	✓		
	2.240	+0.005/-0.000	2.243	✓		
	4.438	+/-0.030	4.438	✓		
	1.780	+0.005/-0.000	1.784	✓		
	R0.063	+/-0.010	.063	✓		
	1.851	+0.005/-0.000	1.855	✓		
	1.928	+0.005/-0.000	1.932	✓		
	2.005	+0.005/-0.000	2.009	✓		
	2.082	+0.005/-0.000	2.086	✓		
	2.159	+0.005/-0.000	2.163	✓		
	2.190	+0.005/-0.000	2.192	✓		
SIDE B	30° x 0.500	+/-0.010	.500	✓		
	0.250	+/-0.010	.250	✓		
	2.240	+0.005/-0.000	2.242	✓		
	4.438	+/-0.030	4.438	✓		
	1.780	+0.005/-0.000	1.785	✓		
	R0.063	+/-0.010	.063	✓		
	1.851	+0.005/-0.000	1.856	✓		
	1.928	+0.005/-0.000	1.932	✓		
	2.005	+0.005/-0.000	2.010	✓		
	2.082	+0.005/-0.000	2.086	✓		
	2.159	+0.005/-0.000	2.163	✓		
	2.190	+0.005/-0.000	2.193	✓		
	100.60	+/-0.020	100.60	✓		

Measured by: BG	Audited by: MB	Prototype Approval:	N/A
Date: 06.10.26	Date: 06/11/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue (P/O D206-667-201)	KJ/JLM	BE

Crosstube Bend Dimension Sheet



PART NUMBER: A206667201

BATCH NUMBER: 29098

DRAWING: 206-667-241 REVISION: B

H: 25.04"

1/2 SPAN: 36.6"

TOTAL SPAN: 73.2"

ANGLE: 65°

QC 15: M

DATE: 07/01/22

QTY: 1

Fit in table
jig



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-667-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (206B HIGH AFT) NTS	
A	00.11.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-06-16 [Signature]

Qty	Part Number	Description
X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
1	D6003-102	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
4	MS21920-20	CLAMP

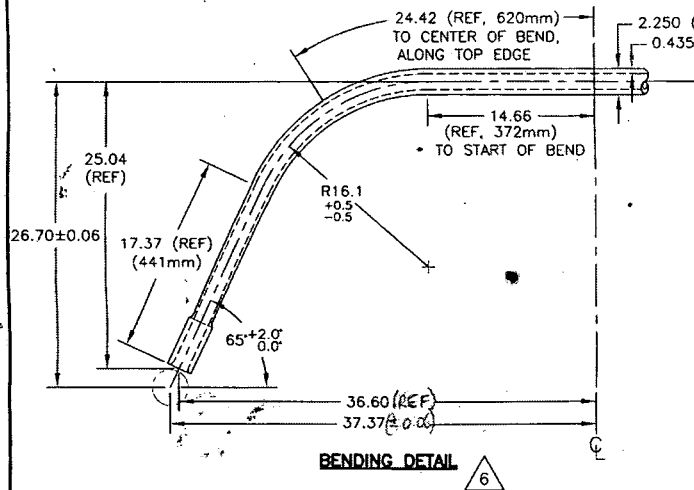
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

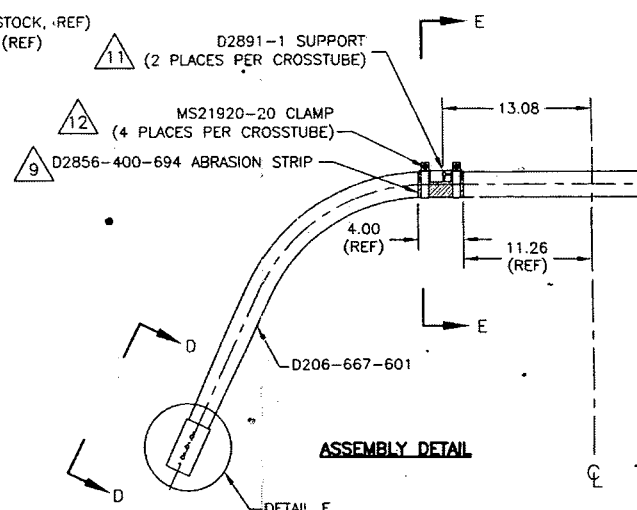
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29098

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



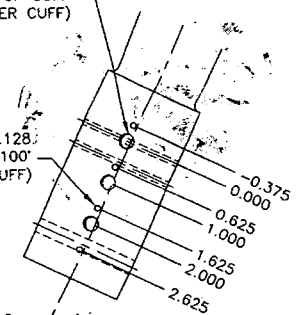
BENDING DETAIL 6



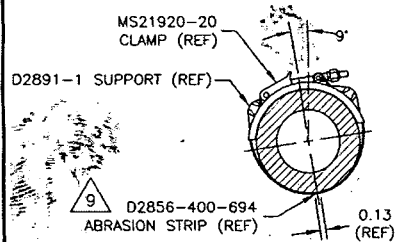
ASSEMBLY DETAIL

B $\phi 0.323^{+0.005}_{-0.000}$
HOLE TO BE ALIGNED WITHIN ± 0.001 OF HOLE ON OTHER SIDE OF CUFF (TYP 6 PLACES PER CUFF)

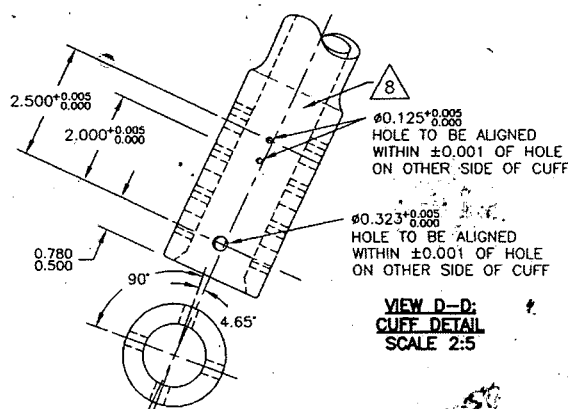
PILOT $\phi 0.128$
C'SINK $\phi 0.225 \times 100$
(TYP 8 PLACES PER CUFF)



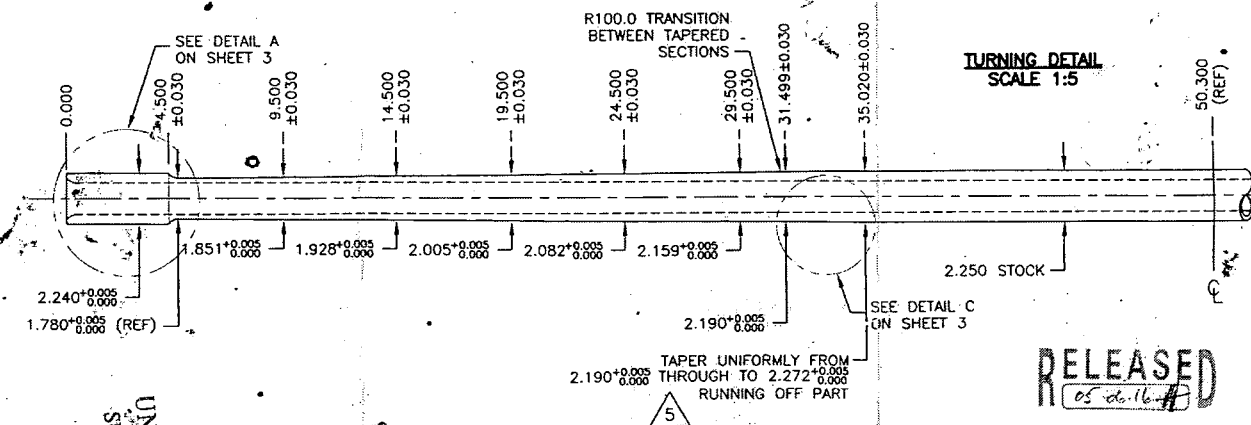
DETAIL F SCALE 2:5



SECTION E-E SCALE 2:5



VIEW D-D: CUFF DETAIL SCALE 2:5



TURNING DETAIL SCALE 1:5

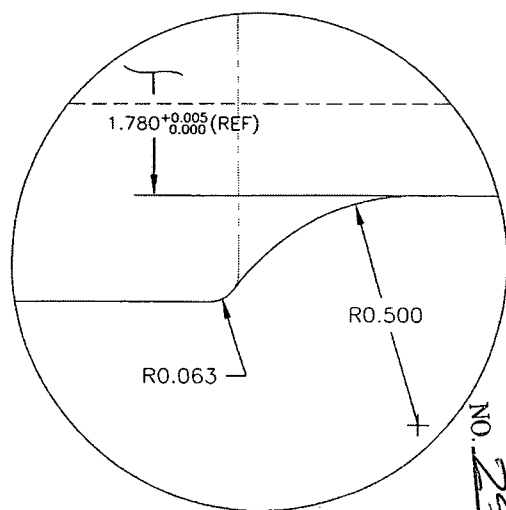
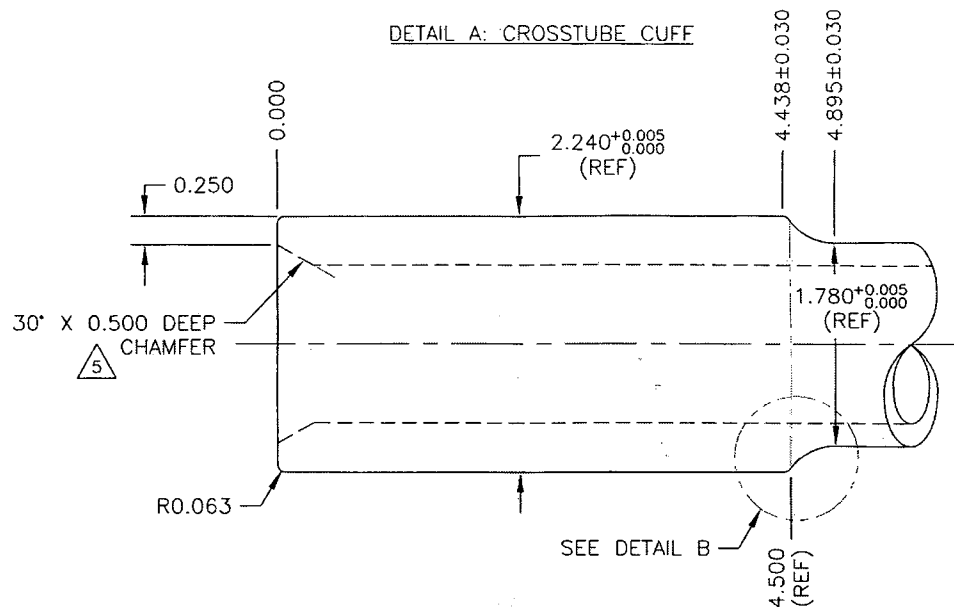
RELEASED
05-06-11

NO. 29098
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO ADDENDUM
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN	DRAWN BY	DART DART AEROSPACE LTD. WILKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	D206-667-241	REV. 8	SHEET 2 OF 3
DATE	05.02.04	TITLE	CROSSTUBE ASS'Y (206B HIGH AFT)	SCALE	1:10

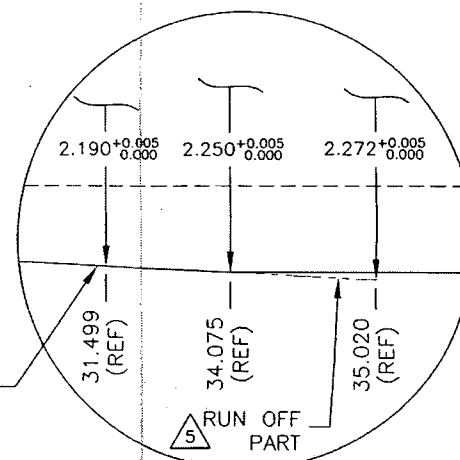
RELEASED
0.5-06-16-04

DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF
TRANSITION
SCALE 4:1

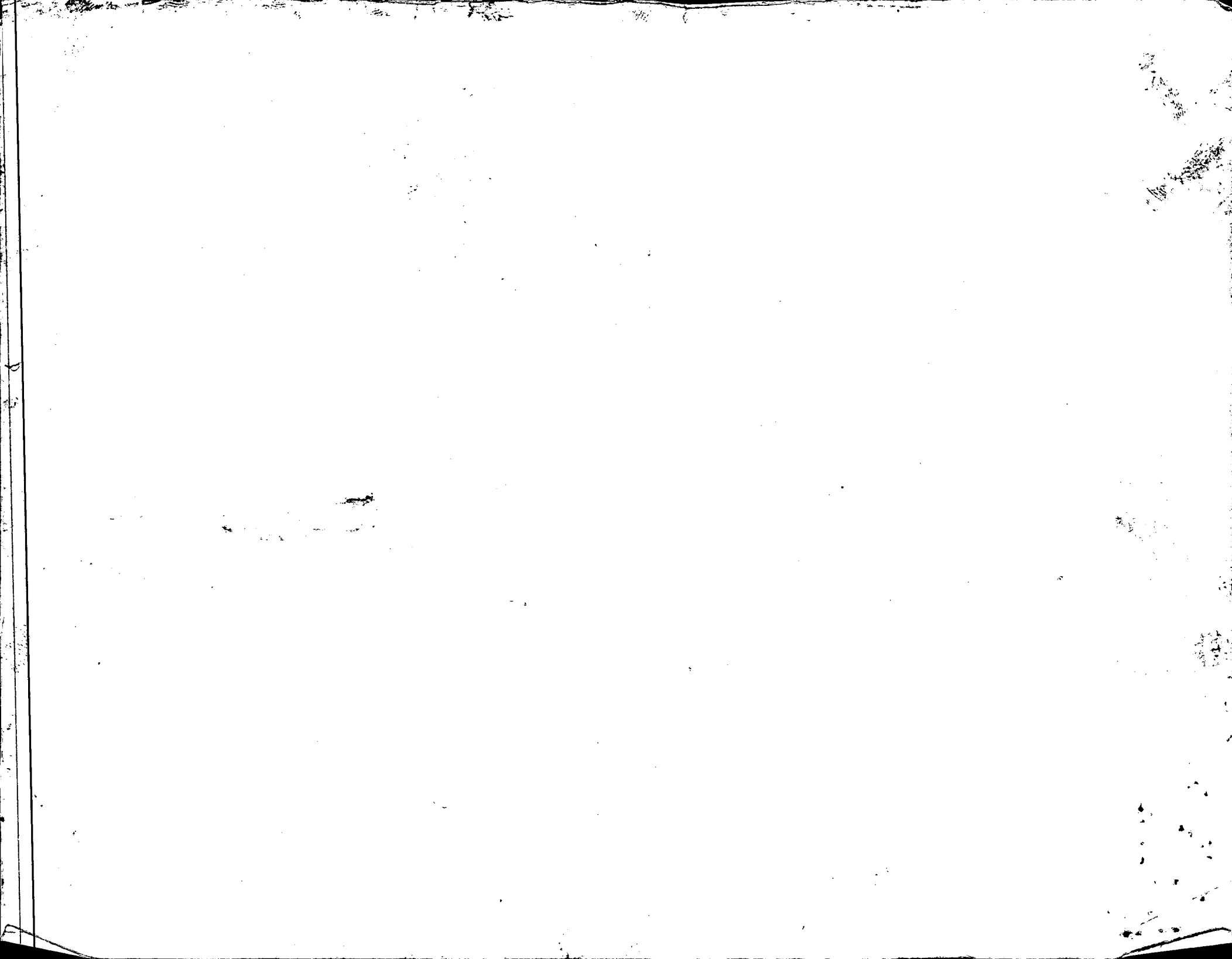
DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 29098

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN	PH	DRAWN BY	PH	DART MARKHAM, ONTARIO, CANADA	DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	#	APPROVED	#		
DATE		05.02.04		DRAWING NO.		D206-667-241	REV. B SHEET 3 OF 3
TITLE		CROSSTUBE ASS'Y (206B HIGH AFT)		SCALE			



**HeathAir**

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35707

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT**AIRCRAFT / COMPONENT INFORMATION**

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (10) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (4) P/N D206-667-101 S/N's B29099, B28680, B29101 and B26864.

Qty (4) P/N D206-667-201 S/N's B30316, B30319, B29098 and B29096.

Qty (2) P/N D407-667-205 S/N's B26323 and B28983.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on (10) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(10) cross tubes inspected. (6) PASSED / (4) FAILED.

Details: Failed S/N's B29099, B28680, B29101 and B29098.
- tubes are marked at locations requiring rework.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE February 12, 2007

INSPECTION
STAMP(S) **CUSTOMER INFORMATION**

CUSTOMER:

Dart Aerospace

P.O. NUMBER

PO 00003046

ADDRESS:

CONTACT NAME: Linda Lacelle

LABOUR

①

F. (613) 632-1053

\$

MATERIALS

②

TRAVEL EXPENSES

③

GST

HOTEL EXPENSES

④

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

**HeathAir**

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36257

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT**AIRCRAFT/COMPONENT INFORMATION**

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (13) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D058-676-101 S/N B30250.

Qty(2) P/N D206-667-103 S/N's B30429 and B28979.

Qty (1) P/N D206-667-203 S/N B29635.

Qty(1) P/N D206-667-201 S/N B29098.

Qty (2) P/N D412-664-245 S/N's B31600 and B31598.

Qty (2) P/N D412-664-145 S/N's B31434 and B31152.

Qty (4) P/N D206-667-101 S/N's B30438, B28680, B29101 and B29099.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on (13) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(13) cross tubes inspected. (10) PASSED / (3) FAILED.

Note: Failed items were serial numbers from above - B30250, B28680 and B29101.
- tubes were marked in areas requiring rework.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE

April 27, 2007.

INSPECTION
STAMP(S) **CUSTOMER INFORMATION**

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00063644

ADDRESS: fax to 613-632-1053

CONTACT NAME: Linda Lacelle

LABOUR

MATERIALS

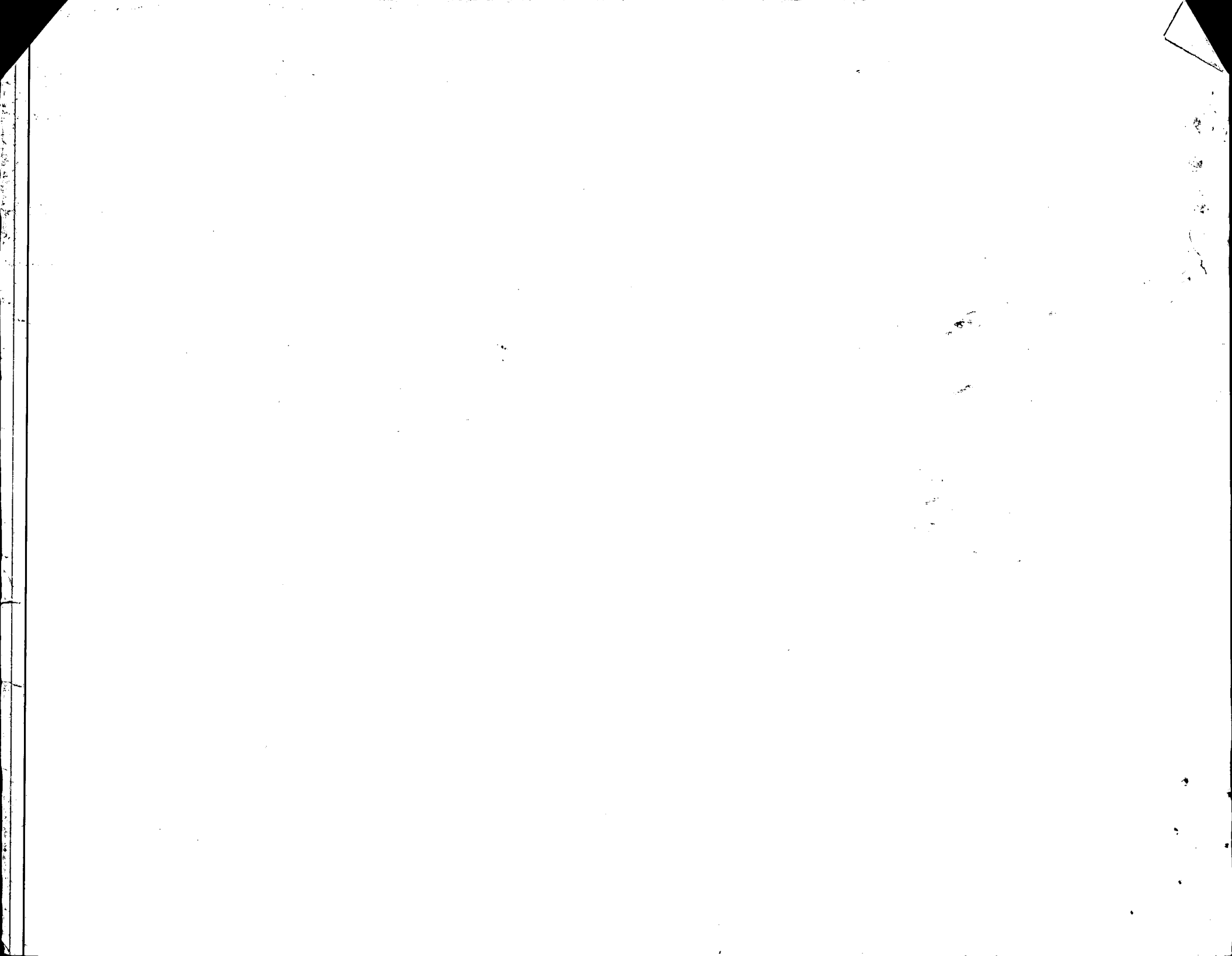
TRAVEL EXPENSES

HOTEL EXPENSES

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT



**HeathAir**

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 836-1000 • Fax: (514) 836-0031

W.O. N° 36257

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT**AIRCRAFT / COMPONENT INFORMATION**

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (13) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D058-676-101 S/N B30250.

Qty(2) P/N D206-667-203 S/N's B30429 and B28979.

Qty (1) P/N D206-667-203 S/N B29635.

Qty(1) P/N D206-667-201 S/N B29098.

Qty (2) P/N D412-664-245 S/N's B31600 and B31598.

Qty (2) P/N D412-664-145 S/N's B31434 and B31152.

Qty (4) P/N D206-667-101 S/N's B30438, B28680, B29101 and B29099.

2
PASSED☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on (13) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(13) cross tubes inspected. (10) PASSED / (3) FAILED.

Note: Failed items were serial numbers from above - B30250, B28680 and B29101.
- tubes were marked in areas requiring rework.THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE

April 27, 2007.

INSPECTION
STAMP(S)**CUSTOMER INFORMATION**

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00003644

ADDRESS: fax to 613-632-1053

CONTACT NAME:

Linda Lacelle

LABOUR

MATERIALS

TRAVEL EXPENSES

HOTEL EXPENSES

\$

GST

PST

INVOICE NO.

TOTAL €